

Work Order ID 62926

Wednesday, October 13, 2010 2:33:06 PM



Page 1

Item ID: D3947-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Lower RH Post

Start Date: 10/13/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 10-10-13

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3947	A

100

0.00



HAND FINISHING THERMOFORMING

x2

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to fit frame size

Dh
10/10/21

105

0.00



Dry Material

x2

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Dh
10/10/21

Temp: 240°F

Time IN: 4:20 pm 10/10/20

Time OUT: 2:00 am 10/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Thermoform

THERMOFORMING MACHINE

Memo

0.00

Thermoforming Machine

1-Machine Set-up

2-Pre-heat tool

3-Thermoform as per Dwg. D3947-4 and Folio FTA 047 using tool DT9484

Dwg. Rev. AFolio Rev. B

x2

Dh

10/10/2010

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect for proper formation of each part

x2

Dh

10/10/2010

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

10-10-2010

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 2.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions as per dwg D3946-1	0.00 0.00				x2.			DL 10/10/21
150  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Check dimensions to ensure conformity to drawing tolerances.	0.00 0.00				x2.			DL 10/10/21
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 8.10/10/26 0.00				(x2)			

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 10/13/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 150

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/14/26 2

10/10/27 MF
10-10-28

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 13, 2010 2:33:10 PM

Page 1

Work Order ID: 62926

Parent Item: D3947-4

Parent Item Name: Panel, Lower RH Post

Start Date: 10/13/2010

Required Date: 10/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

IPP RevB:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.093-F6006-07

Purchased

No

100

sf

1,838.406

3.444

7.250526



GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

therm

1838.406

107574

6.46

112176

101.2267

114459

1730.7193

6.888 sq ft. WK 10/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<i>62924</i>
Description: Panel, Lower RH		Part Number:	D3947-4
Inspection Dwg: D3947	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *W/L* Date: *10/10/21*

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	<i>0.63</i>	✓			
1.6	Min	<i>1.69</i>	✓			
0.050	Min	<i>0.052</i>	✓			
0.065	Min	<i>0.074</i>	✓			
22.5	REF	<i>22.5</i>	✓			
10.8	REF	<i>11.5</i>	✓			

Measured by: *W/L* Date: *10/10/21*
Audited by: *BD* Date: *10/10/21*
Prototype Approval: *N/A* Date: *N/A*

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

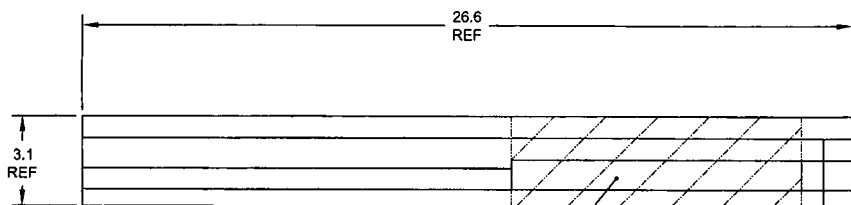
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

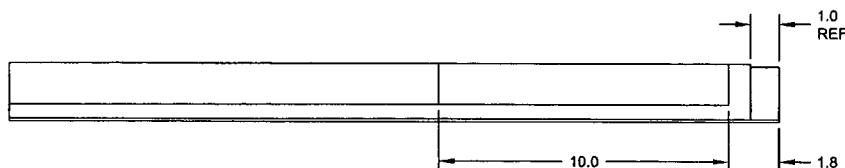
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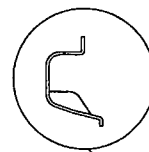
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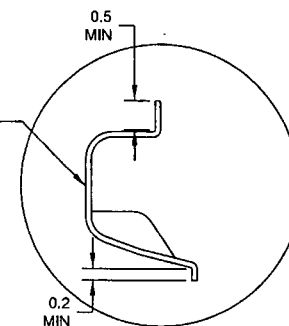
MIN THICKNESS
0.050
(SHADED REGION)



D3947-1 PANEL, LH



DETAIL A C2-1



DETAIL A C3-1
SCALE 2X

UNCONTROLLED COPY
SUBJECT TO RECALL
WORKING COPY
NO. 62926

RELEASED
09/05/2009

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-1" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.42 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9483 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.070" ELSEWHERE

REV.	NEW ISSUE	DESCRIPTION	PH	09.05.20
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.05.20			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A SHEET 1 OF 4
TITLE PANEL (AS 350/355)	SCALE NTS

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8 7 6 5 4 3 2 1

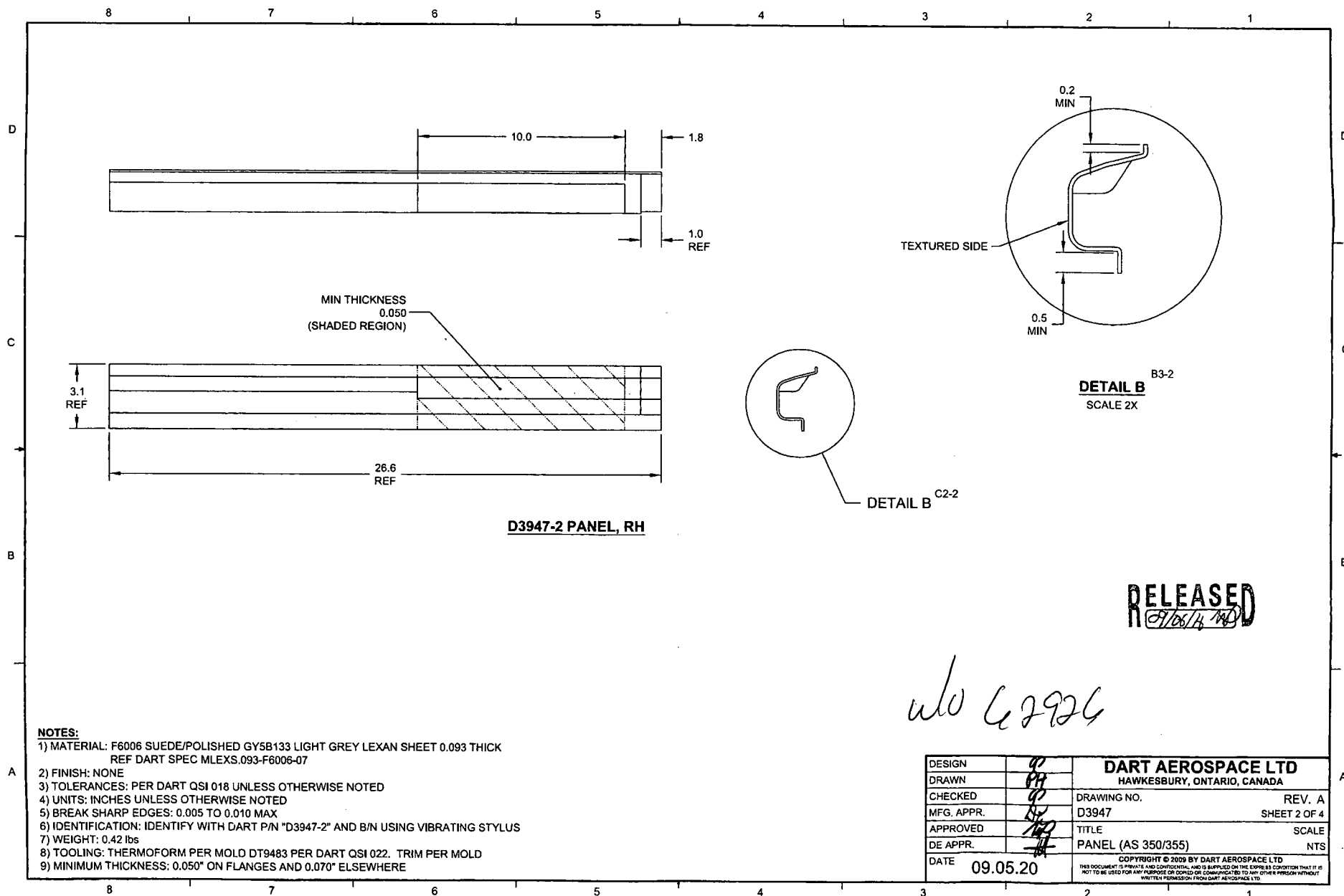
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



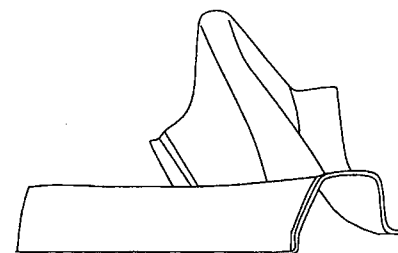
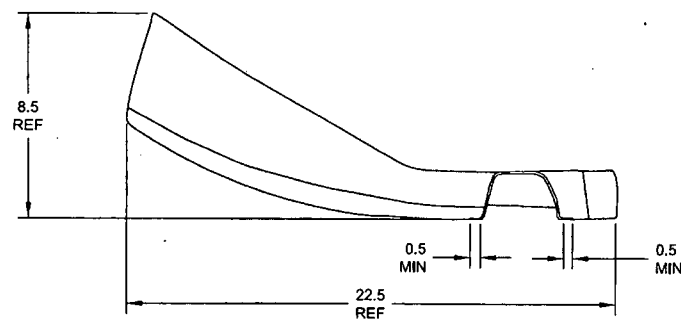
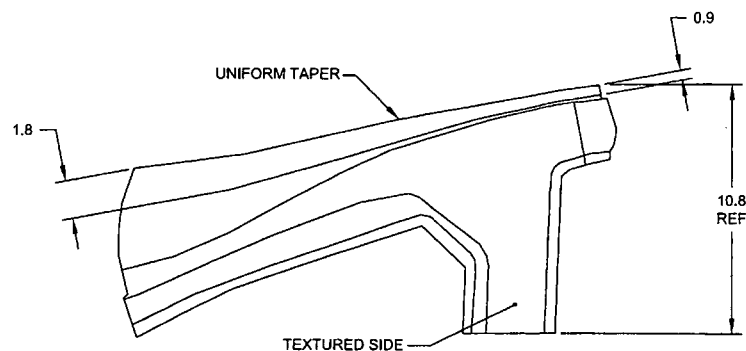
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O 42924

RELEASED
09/06/16

D3947-3 PANEL, LH

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-3" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.55 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	90	DRAWING NO.	REV. A
MFG. APPR.	SS	D3947	SHEET 3 OF 4
APPROVED	24P	TITLE	SCALE
DE APPR.	24P	PANEL (AS 350/355)	NTS
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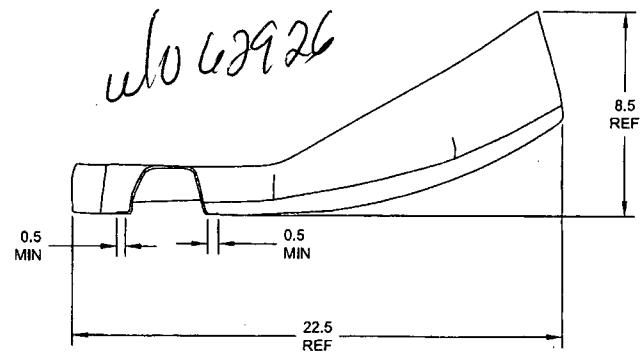
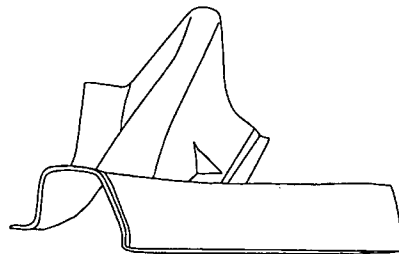
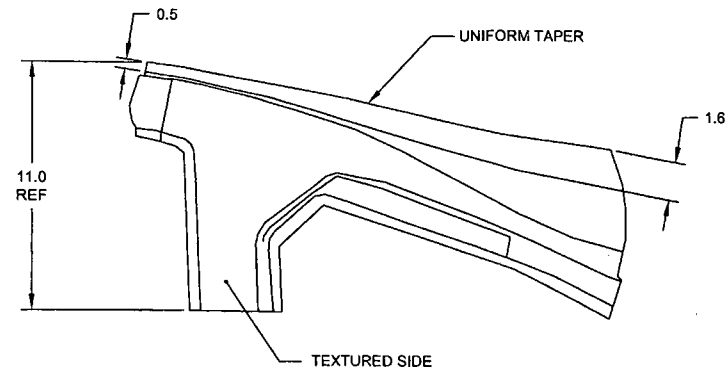
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NOTE: Date & initial all entries



D3947-4 PANEL, RH

RELEASED
09/05/20

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-4" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.62 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

DESIGN	98	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	98	DRAWING NO.	REV. A
MFG. APPR.	98	D3947	SHEET 4 OF 4
APPROVED	98	TITLE	SCALE
DE APPR.	98	PANEL (AS 350/355)	NTS
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